

Work Order ID 51719

August 28, 2009 11:57:16 AM



Page 1

Item ID: D3955-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Plate

Start Date: 8/28/09 Start Qty: 10.00



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3955

A

16

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3955

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B 9-8-09

(16)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-8-09

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August 28, 2009 11:57:16 AM



Page 2

Item ID: D3955-7

Accept



Setup Start



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Item Name: Plate

Start Date: 8/28/09 Start Qty: 10.00



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 808/08/28

(46)

f

130

Identify as per dwg & Stock Location: 139

0.00



Packaging

Memo

0.00

Packaging

Reg/28 (16)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/31

MF 09-08-31

Picklist Print

August 28, 2009 11:57:16 AM

Work Order ID: 51719

Parent Item: D3955-7RevA

Parent Item Name: Plate

Comments:

Start Date: 8/28/09

Required Date: 8/28/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No				sf	56.1547	3.7316			



304/316 0.125 Sheet



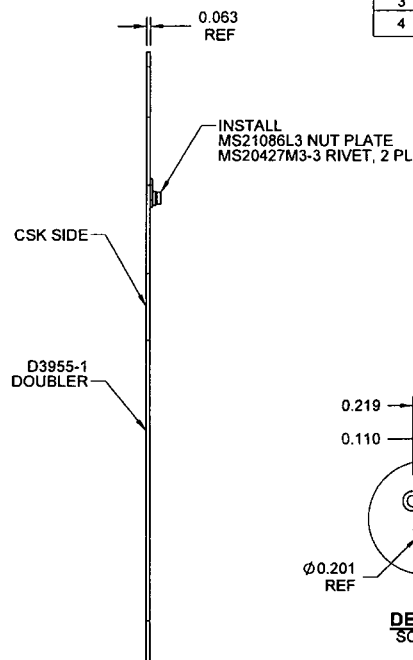
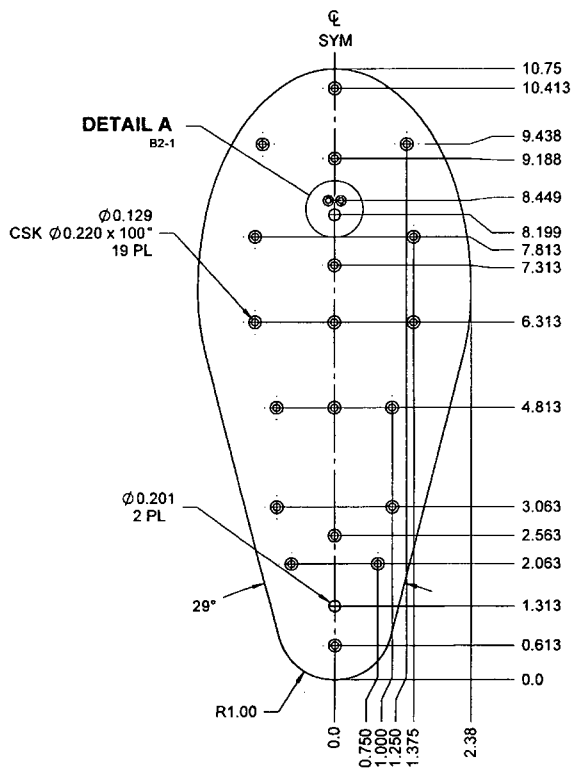
13 9-8-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	56.15469789	
111018	56.1546979	

111018

wlo 5179

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/22

A		NEW ISSUE		RF	09.07.21
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	DART AEROSPACE LTD		REV. A	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		SHEET 1 OF 5	
CHECKED		DRAWING NO. D3955		SCALE	
MFG. APPR.		TITLE SKIDTUBE TUNING KIT		NTS	
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DATE	09.07.21				

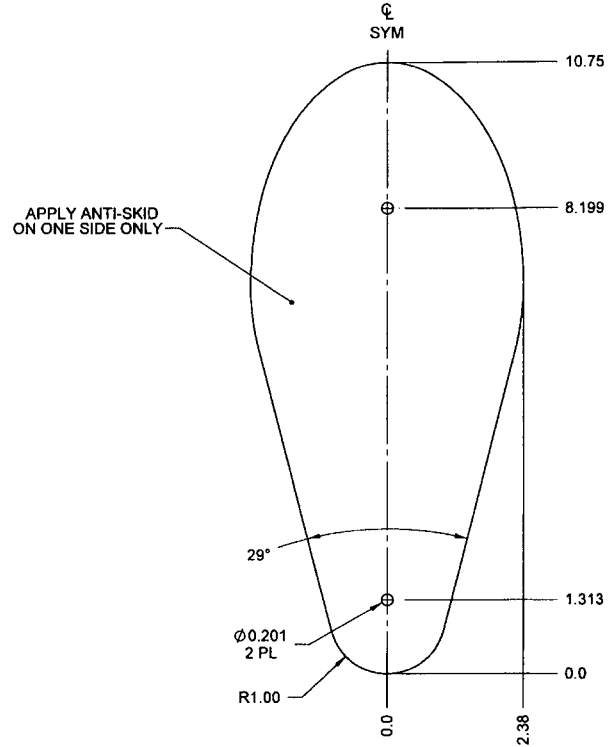
8 7 6 5 4 3 2 1

D

C

B

A



D

C

B

A

51719

D3955-3 COVER PLATE

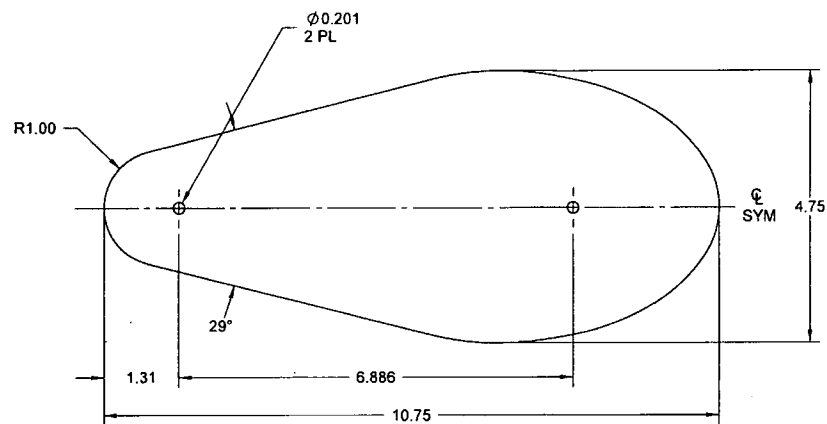
RELEASED
09/07/21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 2 OF 5
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DE APPR.		SKIDTUBE TUNING KIT	NTS
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8 7 6 5 4 3 2 1



D3955-X PLATE

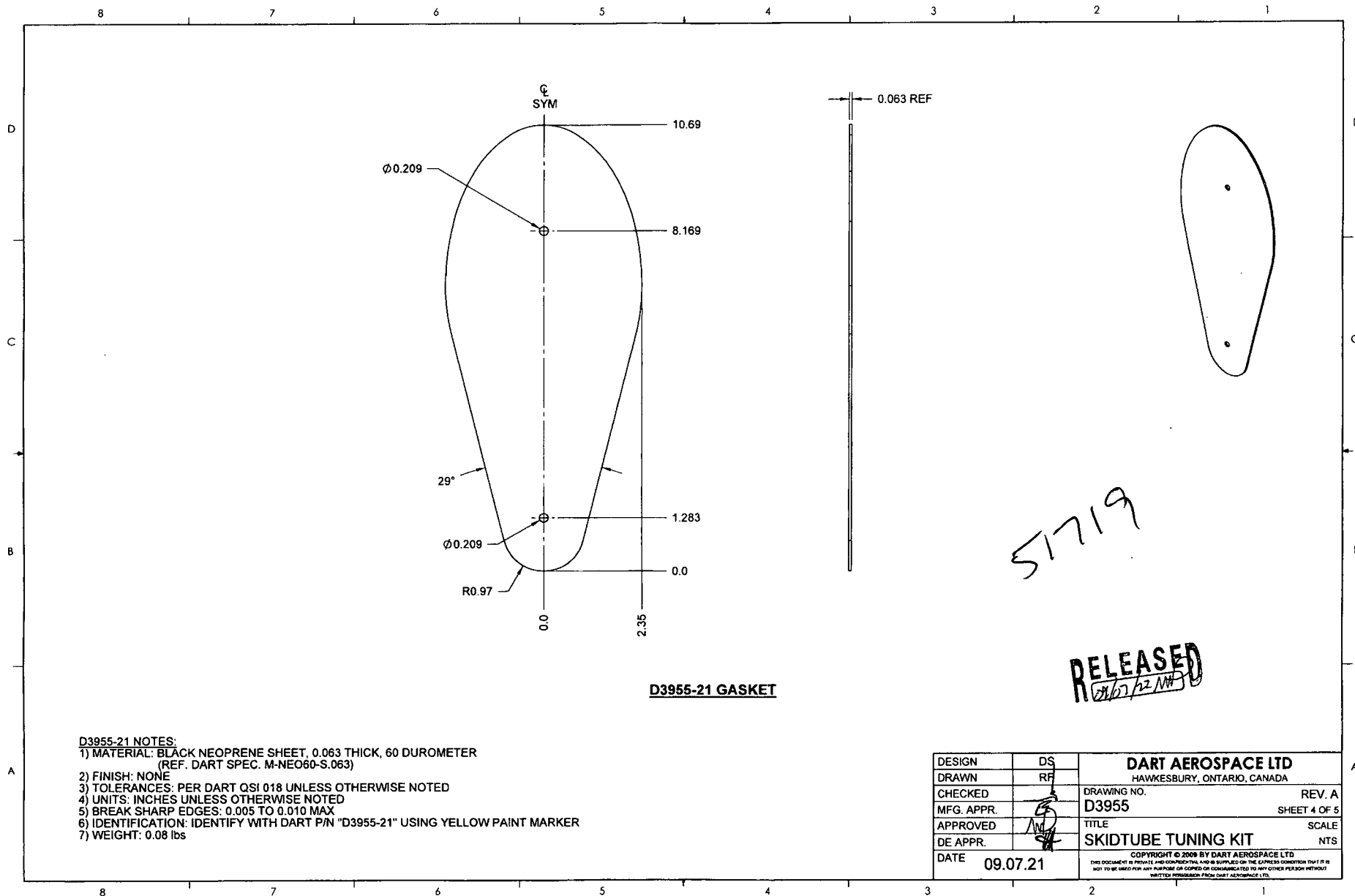
General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'TGA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: SEE TABLE

51719

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01/07/22 MDD

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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APPROVED		TITLE	SCALE
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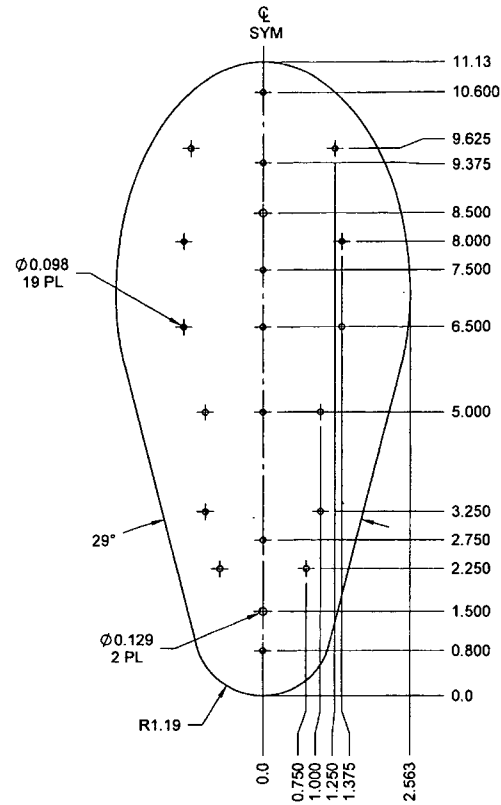
8 7 6 5 4 3 2 1

D

C

B

A



D3955-23 TEMPLATE

51719

RELEASED
09/07/21

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1